

Monday, April 11, 2011 1:44:26 PM

Item ID: D3492-053

Accept

Setup Start

Stop

Item Name: Plug Assembly

Start Date: 4/11/2011 **Start Qty:** 30.00

Cust Item ID:

Required Date: 4/25/2011 **Req'd Qty:** 30.00

Customer:

Reference:

Run Start

Approvals: Process Plan: YMF Date: 11-C4-11 Tooling: Date:

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept
Qty

Reject
Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3492

Rev ~~C~~

0.00

Hardinge CNC LATHE SMALL

0.00

Memo

Hardinge CNC Lathe Small

1-Turn as per Folio FA715 & Dwg D3492 □ Dwg Rev: 1 □ Folio

Rev: N A

0.00

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Quality Control

0.00

QC8- Inspect parts - second check

0,00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68322

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Item ID: D3492-053

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Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

NA 11/6/1

Small Fab

1-Debur

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

N/A

30 4 H 11/06/02

150



Hand Finish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

30 4 H 11/06/02

W/O:		WORK ORDER CHANGES					
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Item ID: D3492-053

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 4/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

(Flat End Only) ☐ START TIME: 4:00 ☐ OVENTEMPERATURE: 4:30 ☐ FINISH TIME: 3200 F

30xØ M-14/06/14

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

30 Ø M 14/06/15

180



Packaging

Packaging

Identify as per dwg & Stock Location: F-PB 0.00

Memo

0.00

30xØ M-14/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 68322

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Revision ID: Stop 
Item Name: Plug Assembly
Start Date: 4/11/2011 Start Qty: 30.00  Cust Item ID:
Required Date: 4/25/2011 Req'd Qty: 30.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>W/6/15</u> 

PA11-0615
(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, April 11, 2011 1:44:22 PM

Page 1

Work Order ID: 68322

Parent Item: D3492-053

Parent Item Name: Plug Assembly



Start Date: 4/11/2011

Required Date: 4/25/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B as per Rev C 07-12-06 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R0.750

Purchased

No

100

f

8.5630

0.0458

1.446316



6061-T6 Round Bar .750"



11/6/11

Location

Loc Qty

Loc Code

MAT013

8.563

112442

0.796

116406

7.767

117481

1.8 ft

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

#65320

RELEASED
2011-05-30

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053. CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	J.F.R.	D3492	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	11.05.24	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

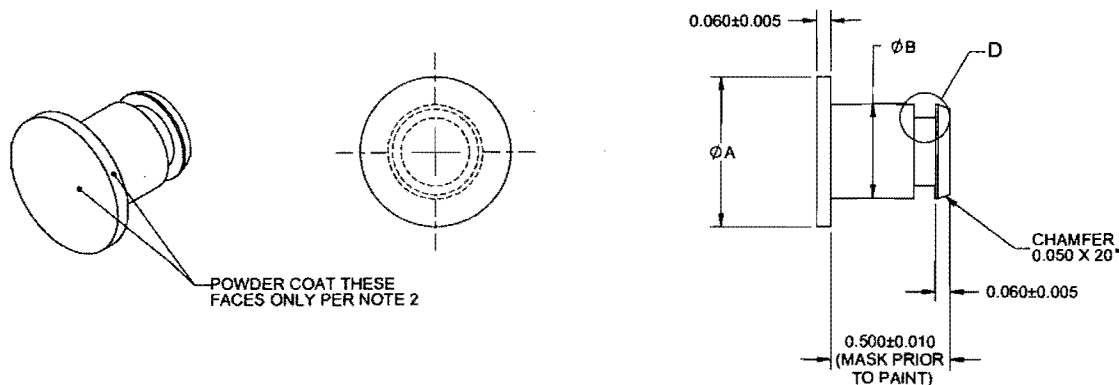
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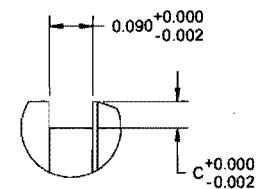
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8 7 6 5 4 3 2 1



D3492-XX PLUG



DETAIL D

#68322

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	△D
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	△D

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2011-05-30

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JES	D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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